

**Work Order ID 59045**

December 7, 2010 11:36:33 AM

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Item ID: D3137-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Washer

Start Date: 5/25/10

Start Qty: 5.00

Required Date: 5/26/10

Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3137

Rev F

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Machine as per Folio FA471 and Dwg D3137-2-Identify as D3137-5-3-  
Deburr

SH 10/12/10

11 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11 0

SH 10/12/10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control







11 0




SH 10/12/10

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Item ID:	D3137-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Washer					
Start Date:	5/25/10	Start Qty: 5.00		Cust Item ID:		
Required Date:	5/26/10	Req'd Qty: 5.00		Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00		20 10/12/13		11.	9		
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				11			BR 10-12-13
150  QC Quality Control	QC5- inspect part completeness to step on W/O  Memo Inspect work to Step 7	0.00 0.00		a/a S 10/12/14					U.O.I.

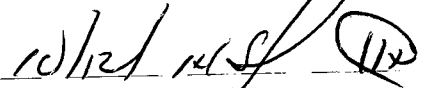
**Work Order ID 59045**

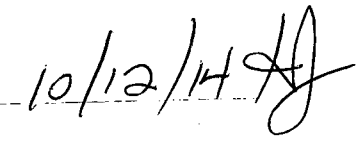
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Item ID:	D3137-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Washer					
Start Date:	5/25/10	Start Qty: 5.00		Cust Item ID:		
Required Date:	5/26/10	Req'd Qty: 5.00		Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:		Run	Start
	QC:	Date:	SPC (Y/N):			Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp Stamp
160 	Identify as per dwg & Stock Location: <u>2356</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/12/14 

10/12/14 

6-12-14

# Picklist Print

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Work Order ID: 59045



Parent Item: D3137-5



Parent Item Name: Washer

Start Date: 5/25/10

Required Date: 5/26/10

Start Qty: 5.00

Required Qty: 5.00

## Comments:

IPP ☐ A ☐ 04.11.04 ☐ New issue ☐ KJ/JLM ☐  
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.750

Purchased

No

100

f

2.4648

0.0208

0.109474



6061-T6 Round Bar-.750"

### Location

### Loc Qty

### Loc Code

MAT

2.448

115469

0.0027

115869

2.4453

MAT012

0.016842105

112442

0.01684211

115609

1.0" 6061-T6  
This Batch  
only  
10.12.10

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	5904
<b>Description:</b> Washer		<b>Part Number:</b>	D3137-5
<b>Inspection Dwg:</b> D3137 <b>Rev:</b> F		<b>Page 1 of 1</b>	

## FIRST ARTICLE INSPECTION CHECKLIST

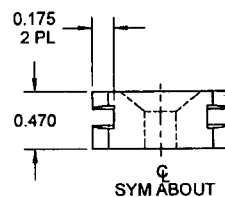
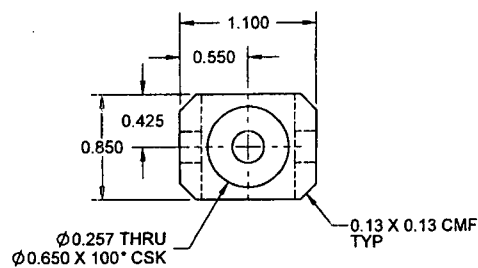
**X**

## Prototype

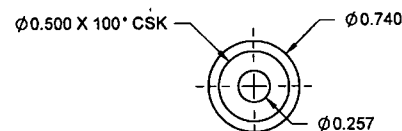
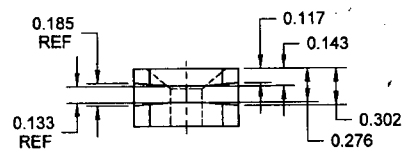
[illegible]

Measured by:	<i>SA</i>	Audited by:	<i>one</i>	Prototype Approval:	N/A
Date:	<i>10/2/10</i>	Date:	<i>10/2/10</i>	Date:	N/A

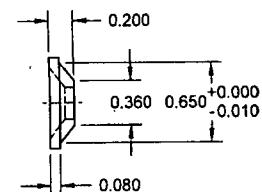
Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	06.03.15	Ø0.650 dimension added; Ø0.660 dimension removed	KJ/JLM	
C	08.12.02	Dwg Rev updated	KJ/DD	



**D3137-3 GUIDE**



**D3137-5 WASHER**



*W/S 59045*

**NOTES:**

- 1) MATERIAL: -3  
DELTRIN II 150E OR ACETRON GP ACETAL, BAR  
(REF DART SPEC M-DELTRIN-B)  
-5  
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR  
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)  
OR PER-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207  
-5 REPLACES PREMIER P/N B30-2300-209

**RELEASED**  
*28-07-02/14*

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	